

Date: Wednesday, 8/8/2007 8:57:54 AM
 User: Jean-Luc Menard

Process Sheet

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LUG ASSEMBLY |
| Job Number : 33843 | |
| Estimate Number : 10774 | |
| P.O. Number : N/A | Part Number : D3414041 |
| This Issue : 8/8/2007 S.O. No. : N/A | Drawing Number : D3414 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A | Drawing Revision : A |
| Previous Run : 33264 | Material : N/A |
| Written By : <u>Jul 07-08-08</u> | Due Date : 8/15/2007 |
| Checked & Approved By : _____ | Qty: 30 Um: Each |
| Comment : Est A 05.09.13 New issue KJ/JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S12GA | 304/316 .100" Sheet |
|-----|-----------|---------------------|



Comment: Qty.: 0.1523 sf(s)/Unit Total : 4.5675 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: M105130 IB 07-08-09

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: A

Prog Rev: A

IB 07-08-09

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



IB 07-08-09

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

IB 07/08/09

counter

X30

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr and open holes to correct diameter ϕ .513

Form using DT8254 as per Dwg D3414

IB 07/08/15 (30)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 33843

Part Number: D3414041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

en 07/08/15 (30) *coated*

7.0 D34143 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D3414-3 Lug

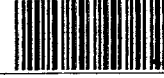
A/R SS Rod

B 33950
M102421

07/09/08

(30x)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

07/09/08 (30x)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/10 (30)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/10 (30)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

(30x)

07/09/11

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/09/11 (30)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57470

07/09/11 (30)

Date: Wednesday, 8/8/2007 8:57:54 AM
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Process Sheet

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Drawing Name: LUG ASSEMBLY

Job Number: 33843

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/11

Job Completion

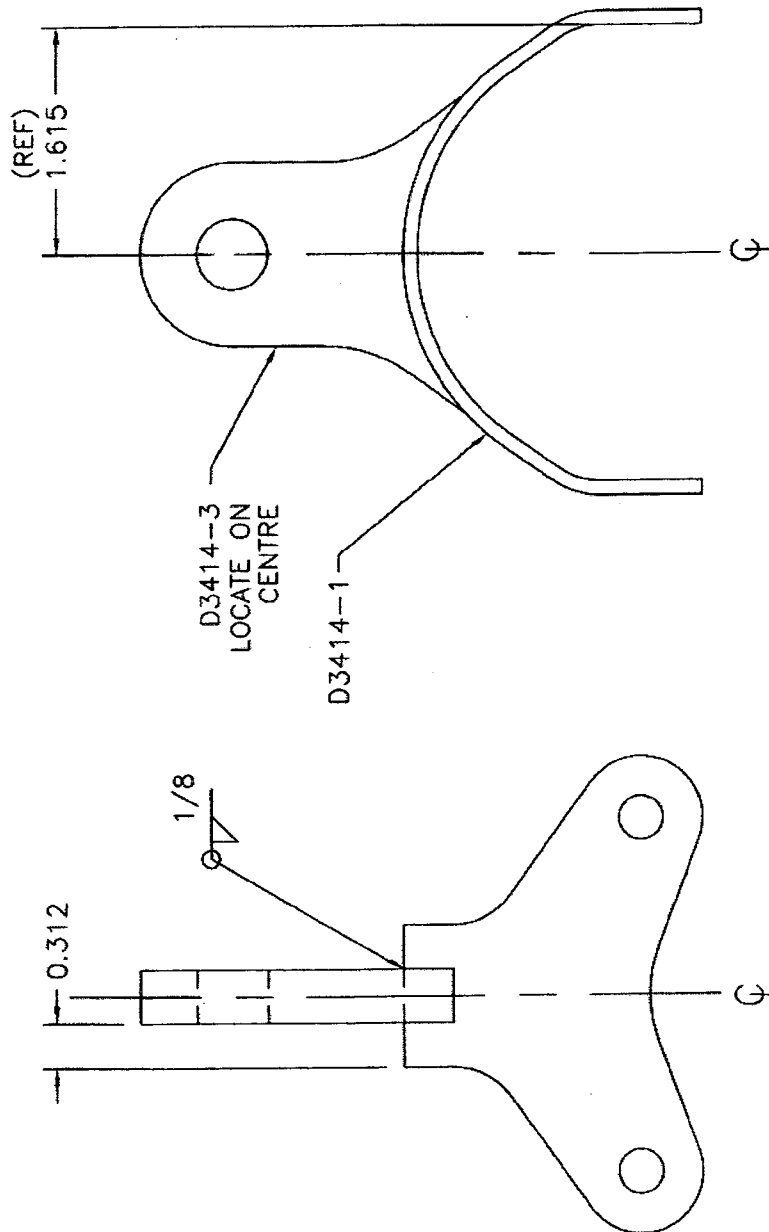


U 07-09-11



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3414 | REV. A SHEET 1 OF 3 |
| DATE 05.03.16 | | TITLE LUG ASSEMBLY | SCALE NTS |
| A | 05.03.16 | NEW ISSUE | |

RELEASED
05-09-06 *[Signature]*



D3414-041 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

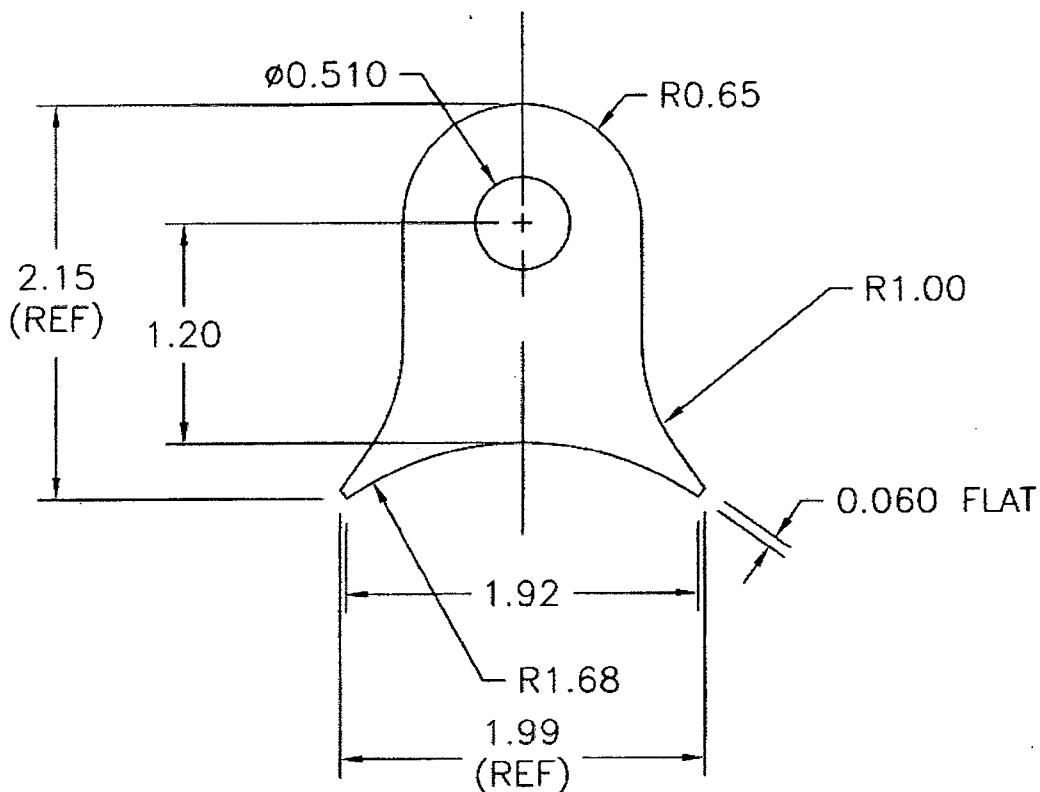
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3414 | REV. A SHEET 3 OF 3 |
| DATE 05.03.16 | | TITLE LUG ASSEMBLY | SCALE 1:1 |

RELEASED
05-07-06 *[Signature]*



D3414-3 LUG

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

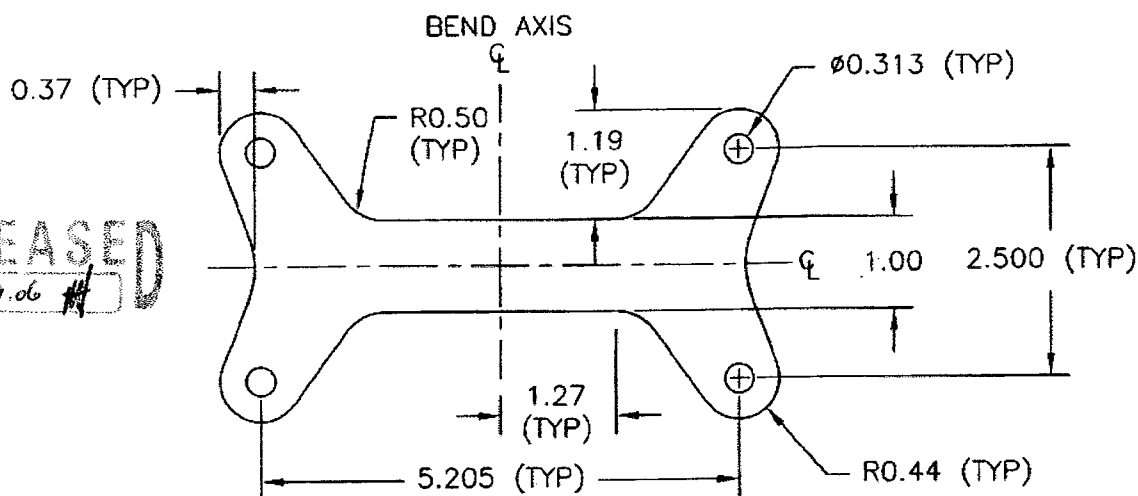
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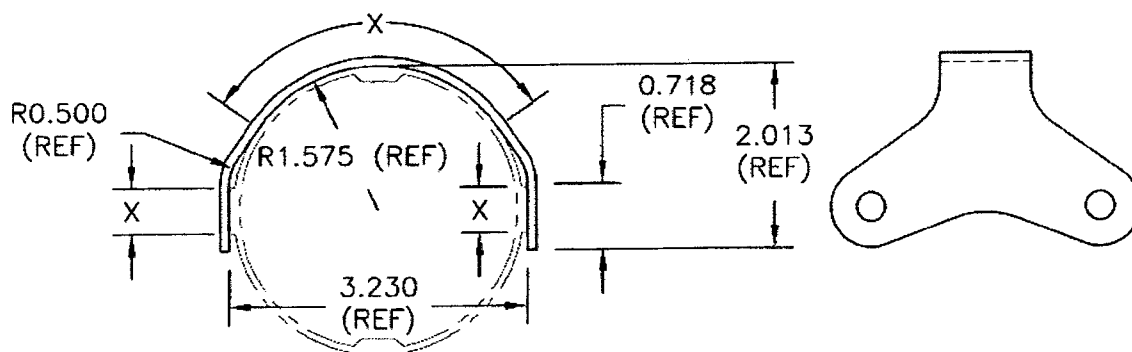
| | | | |
|------------------|-----------------------|--|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. D3414 | REV. A SHEET 2 OF 3 |
| DATE 05.03.16 | TITLE LUG ASSEMBLY | | SCALE 1:2 |

RELEASED
05.09.06



D3414-1 FLAT PATTERN

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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